

# Work Order ID 75864

**\*75864\***

Page 1

Thursday, November 17, 2011 4:13:50 PM

Item ID: K10111 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Skidtube 206  
 Start Date: 11/1/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 12/9/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: 11-11-17 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	<b>*SP*</b>							
DSI 9583	A								
K10111	B								
100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP K10111 CHG003 FOR D206-642-111 CHG006 <i>CHG006</i> FOR D206-642-113 CHG002								<i>S 12/01/12</i>
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							<i>SP 12-01-05.</i>
Packaging									

*[Signature]* For MLT 12-1-5  
 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75864

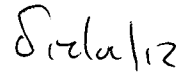
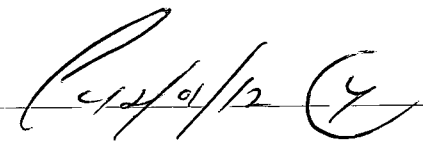
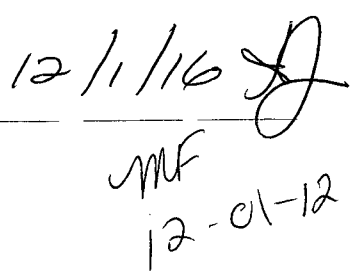
**\*75864\***

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Thursday, November 17, 2011 4:13:51 PM

Item ID: K10111 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Skidtube 206  
 Start Date: 11/1/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 12/9/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00							
130 <b>*130*</b> Packaging Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP PPP D206-642-111 PPP D206-642-113 Location: _____ PPP rev: _____	0.00 0.00							
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Thursday, November 17, 2011 4:13:55 PM

**\*75864\***

**\*K10111\***

**Start Date:** 11/1/2011**Required Date:** 12/9/2011

**Start Qty: 4.00**

**Required Qty: 4.00**

21SM

IPP REV:G

11.09.23 PER REV.B DD VERF:EC

IPP REV:H 11.11.14

AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A		Purchased	No				Each	872.0000	4	16			
*AN5-10A*													
Bolt									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST337				872					
				116704				11					
				118191				59					
				119547				802					
AN5-11A		Purchased	No				Each	1,599.000	4	16			
*AN5-11A*													
Bolt									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST337				21					
				117313				2					
				118191				19					
				ST518				1578					
				119512				1578					
AN3-41A		Purchased	No			110	Each	1,655.000	8	32			
*AN3-41A*													
Bolt									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st510				1655					
				119042				1655					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Thursday, November 17, 2011 4:13:56 PM

Work Order ID: 75864

**\*75864\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A Purchased No 110 Each 5,062.000 12 48

\*\*

SP

**\*AN4-6A\***

Bolt

Location Loc Qty Loc Code

ST356 62

119127 62

ST516 5000

119017 5000

110 Each 489.0000 1 4

\*\*

48x

SP

AN4C5A

Purchased No

**\*AN4C5A\***

BOLT

Location Loc Qty Loc Code

FP-B 49

112243 49

ST355 440

112243 340

119017 100

110 Each 511.0000 2 8

\*\*

4x

SP

AN6-44A

Purchased No

**\*AN6-44A\***

Bolt

Location Loc Qty Loc Code

ST343 7

119127 7

st510 504

119036 504

110 Each 1.0000 1 4

\*\*

8x

B76580 2x

2x B. 76 578 / 01/2/11/12

SP 12-01-06

D206-651-041

CHC701

Manufactured No

**\*D206-651-041\***

206A/B GHW

Location Loc Qty Loc Code

FG125 1

74002 1

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Thursday, November 17, 2011 4:13:56 PM

Work Order ID: 75864

**\*75864\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2652

Manufactured No

110

Each

743.0000

16

64

**\*D2652\***

Bushing

\*\*

B76132 64x 8p.

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

D2661-1

Manufactured No

110

Each

18.0000

2

8

**\*D2661-1\***

Saddle, LH Fwd Aft Out 206

\*\*

B76749 8p.  
8x

Location

Loc Qty

Loc Code

MEZZ

5

64559

5

ST435

13

73838

10

73841

1

76516

2

D2662-1

Manufactured No

110

Each

20.0000

2

8

**\*D2662-1\***

Saddle, LH In 206

\*\*

B76771 7x.  
8p 12-01-06.

Location

Loc Qty

Loc Code

ST435

10

73846

1

74479

9

ST476

10

74481

10

1x -> B76804.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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Thursday, November 17, 2011 4:13:56 PM

Work Order ID: 75864

**\*75864\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2712- Manufactured No

110 Each 2,551.000 10 40

\*\*

SP

**\*D2712\***

Set Screw

Location

Loc Qty

Loc Code

FG	50	
29962	50	
ST021	2501	
71160	1	
73837	500	
76065	2000	

40x

D2884- Manufactured No

110 Each 100.0000 2

\*\*

B 76751 SP

**\*D2884\***

Saddle Spacer

Location

Loc Qty

Loc Code

FG	10	
29453	10	
ST025	90	
73823	90	

8

D2885- Manufactured No

110 Each 126.0000 2

\*\*

B 76752 SP  
12-01-05

**\*D2885\***

Saddle Spacer

Location

Loc Qty

Loc Code

FG	10	
29199	10	
ST025	116	
73824	116	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, November 17, 2011 4:13:56 PM

Work Order ID: 75864

**\*75864\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D3413-1

Manufactured No

110

Each

94.0000

1

4

**\*D3413-1\***

\*\*

SP

Ring

Location

Loc Qty

Loc Code

ST368

2

73821

2

ST420

2

66387

1

70773

1

ST469

88

73822

88

4X

ST473

2

71041

2

MS21042L3

Purchased

No

110

Each

8,781.000

8

32

**\*MS21042L3\***

\*\*

SP

Nut

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

32X

ST518

2526

119075

2526

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Thursday, November 17, 2011 4:13:56 PM

Work Order ID: 75864

**\*75864\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

11,520.00

12

48

**\*MS21042L4\***

\*\*

Nut

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5962

119017

5962

ST518

5000

119075

5000

MS21042L6

Purchased

No

110

Each

1,484.000

2

8

**\*MS21042L6\***

\*\*

Nut

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

ST518

1000

119075

1000

NAS1149C0463R

Purchased

No

110

Each

1,379.000

1

4

**\*NAS1149C0463R\***

\*\*

Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

Thursday, November 17, 2011 4:13:56 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Thursday, November 17, 2011 4:13:56 PM

Work Order ID: 75864

**\*75864\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

4,466.000

8

32

**\*NAS1149D0363.I\***

\*\*

SP

Washer

## Location

## Loc Qty

## Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

32x

ST298

1450

117601

148

118077

1

118612

55

118968

1246

NAS1149D0463J

Purchased

No

110

Each

12,710.00

24

96

**\*NAS1149D0463.I\***

\*\*

SP 12-01-05.

Washer

## Location

## Loc Qty

## Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12386

119075

10000

119097

2386

32x96x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Thursday, November 17, 2011 4:13:56 PM

Work Order ID: 75864

**\*75864\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

5,153.000

8

32

**\*NAS1149D0563.I\***

\*\*

SP

Washer

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3153

118206

2153

118614

1000

32x

NAS1149D0663J

Purchased

No

110

Each

2,598.000

4

16

**\*NAS1149D0663.I\***

\*\*

SP 12-01-05

Washer

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

16x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>140</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BE</i>	K10111	SHEET 1 OF 1
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	SADDLE KIT	NTS
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	